

Work Order ID 70850

Thursday, June 16, 2011 2:19:45 PM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Item Name: Handle Weldment

Stop



Start Date: 6/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11/06/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2530

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536
2-Deburr

110

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

120

0.00



Weld per dwg A/R S.S. rod Batch: 117884

Small Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

Large Fab

Signature 6/16/21 (12)

(4/2)

Signature 11.07.06 (X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70850

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Thursday, June 16, 2011 2:19:46 PM

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Accept



Setup Start



Revision ID:

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Item Name: Handle Weldment

Start Date: 6/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

BE 11/07/06



QC

Memo

0.00

11-07-06

12 0

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8-11-07-06

(12)

Quality Control

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320 OF
10:00

12x 0 m 11/07/12

Powder Coating

M 115128

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 70850

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Thursday, June 16, 2011 2:19:46 PM

Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 6/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 0 11/07/12

170

Identify as per dwg & Stock Location: 540

0.00



Packaging

Memo

0.00

Packaging

11/7/12 (12)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13

ME 11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 2:19:53 PM

Page 1

Work Order ID: 70850

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

100

f

238.7586

2.9145

30.67895

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT017

238.75863

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117030

3.09263

117797

0.75

117983

200

D2534

Manufactured

No

120

Each

6.0000

2

Lock Plate

Location

Loc Qty

Loc Code

WA

6

69938

6

Handwritten: 5/11/06/21

Handwritten: 8.7435
26.2305

Handwritten: 2024
6/11/07.05

Handwritten: 16
370996 - 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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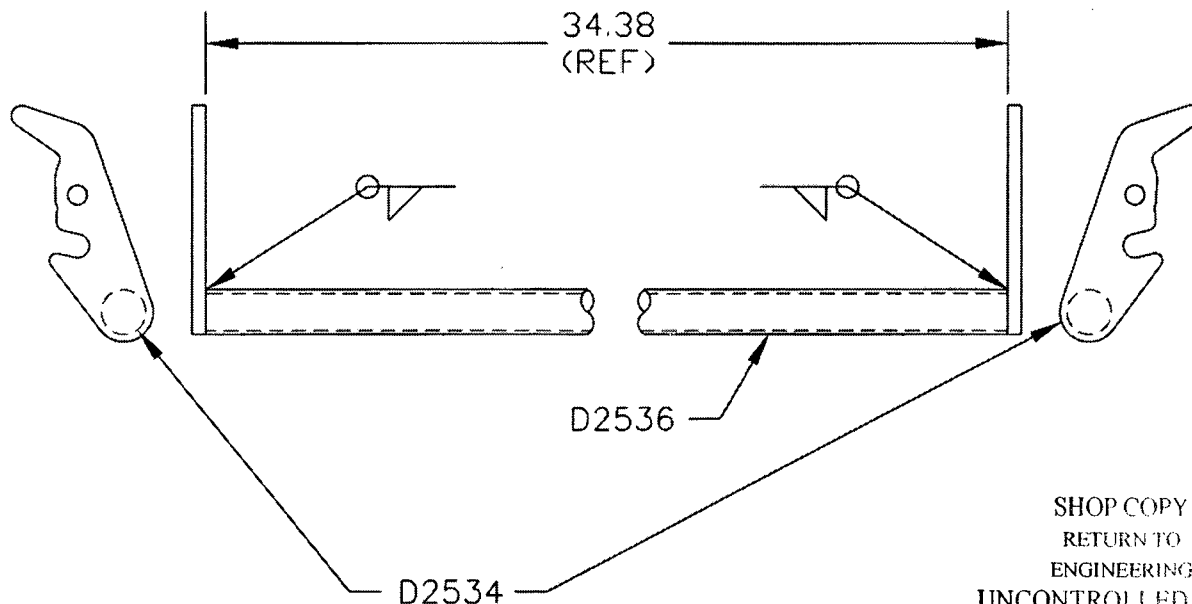
DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70850

PL 11-06-16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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